

## ABSTRACT OF THE DISCLOSURE

Functional blocks (a numerical control unit 22, servo control unit 26, PLC control unit 24, sizing control unit 23, sampling control unit 25, and display control unit 21) carry out their respective functions of control processing. Numerical control data, PLC control data, and sizing data as details of numerical control processing, PLC control processing, and sizing processing, respectively, are sampled and recorded by sampling control processing. The three kinds of recorded data are displayed together on one display unit 80 by display control processing when a display instruction is given by an operator of a control system 10 through an input control unit 90. Thus, an operator of the control system 10 can carry out the work of tracing the cause of the trouble of a machine tool 70 and of examining efficient machining processes of the machine tool 70 by simultaneously watching the control data displayed on one display unit 80. This provides a control system of the machine tool that can improve workability.

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